

Ship Dec 1

Work Order ID 152532

152532

Page 1

Wednesday, November 02, 2016 11:47:00 A

Item ID: D4881-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 206A/B AFT Leg Assembly, LH
 Start Date: 10/27/2016 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/4/2016 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: dm Date: 10/10/27 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4881	C								
110		0.00							
110									
Small Fab	Memo	0.61							
Small Fab	ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 AND D4885-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9973 AS PER DWG.								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.45							
Quality Control									

Pick kit

NOV 17 2016

DAS
6
9-89

4

FF

NOV 21 2016

DAS
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9-89

4

NOV 22 2016

Work Order ID 152532***152532***

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Wednesday, November 02, 2016 11:47:00 A

Item ID: D4881-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206A/B AFT Leg Assembly, LH
Start Date: 10/27/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/4/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Small Fab	Memo	0.21							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL OR MAGNOBOND 6398 WHILE STILL WET AS PER DWG USE DT9974 A/R BATCH: <u>17134167</u>								NOV 22 2016
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.01							
Quality Control									DAS 38 9-8c NOV 22 2016
150	Outsource process - Laser Marking	0.00							
150									
Outsource9	Memo	0.00							
Outsource process - Laser Marking	ISSUE P/O : <u>34420</u> OUTSOURCE VENDOR: P&L PRINTING ENGRAVE P# AS PER DWG C OF C IS REQUIRED								NOV 23 2016 DAS 13 9-8c

Work Order ID 152532

Wednesday, November 02, 2016 11:47:00 A

152532

Page 4

Item ID: D4881-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** 206A/B AFT Leg Assembly, LH**Start Date:** 10/27/2016 **Start Qty:** 4.00***4*****Cust Item ID:****Required Date:** 11/4/2016 **Req'd Qty:** 4.00***4*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start*****NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.07					DAS 21 9-89	NOV 30 2016	
Quality Control									

DAS
21
9-89

NOV 30 2016

Picklist Print

Wednesday, November 02, 2016 11:47:51 AM

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Work Order ID: 152532

152532

Parent Item: D4881-041

D4881-041

Parent Item Name: 206A/B AFT Leg Assembly, LH

Start Date: 10/27/2016

Required Date: 11/4/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP
REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

HL32PB5-12

Purchased

No

Each

115.0000

16

HI 32PB5-12

Hi-Lok Pin

Location

Loc Qty

Loc Code

Mezz

115

M129912

115

D4881-1

Manufactured

No

Each

11.0000

4

D4881-1

Strut

Location

Loc Qty

Loc Code

ST133

11

121698

3

124003

8

D4885-1

Manufactured

No

Each

13.0000

4

D4885-1

End Fitting

Location

Loc Qty

Loc Code

ST135

13

121051

3

124011

10

D4885-3

Manufactured

No

Each

15.0000

4

D4885-3

End Fitting

Location

Loc Qty

Loc Code

ST135

15

121467

6

124007

9

NOV 29 2016
DAS 6 9-88

NOV 29 2016
DAS 6 9-88

NOV 29 2016
DAS 6 9-88

NOV 29 2016
DAS 6 9-88

NOV 29 2016

Picklist Print

Wednesday, November 02, 2016 11:47:51 AM

Page 2

Work Order ID: 152532

152532

Parent Item: D4881-041

D4881-041

Parent Item Name: 206A/B AFT Leg Assembly, LH

Start Date: 10/27/2016

Required Date: 11/4/2016

Start Qty: 4.00

Required Qty: 4.00

HL86-5

Purchased

No

Each

536.0000

16

HI 86-5

Hi-Lok Collar

DAS
6
9-89

NOV 17 2016

Location

Loc Qty

Loc Code

ST562

536

M129022

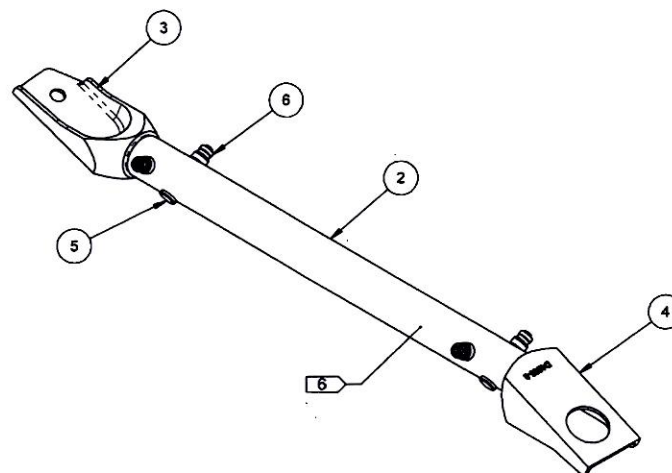
200

M129864

336

16

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4881-041	AFT LEG ASSEMBLY, LH
2	1	D4881-1	STRUT
3	1	D4885-1	END FITTING
4	1	D4885-3	END FITTING
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4881-041 AFT LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-103-017)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.77 lbs
- 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 & D4885-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø 0.1610) REAMER, USING DART TOOL SETUP DT9973
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9973
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

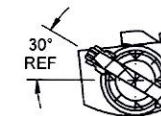
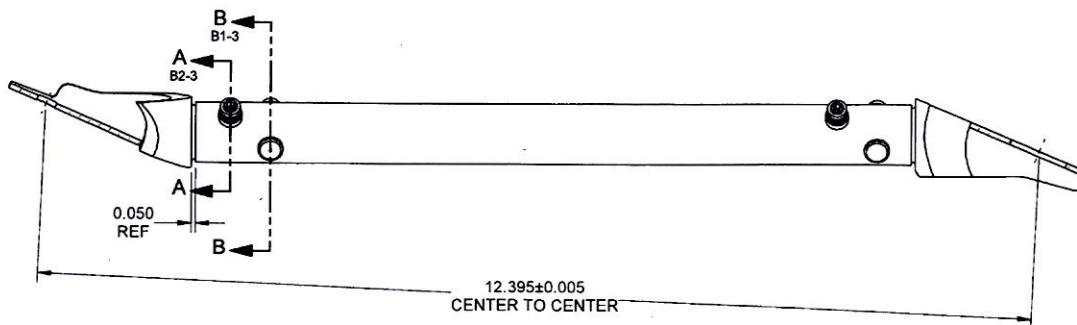
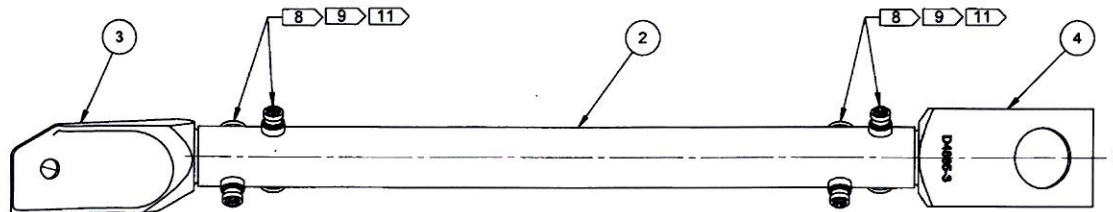
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152532

dem 16/10/27

RELEASED
2014-07-07

C	HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 6) (ZN A8-5)	RF	14.06.24
B	REVISE NOTES 6), 7) & 9) (ZN A8-1, A8-3); ADDED BELL PIN; REVISE SECTIONS A-A, B-B, C-C, D-D (ZN B1-2, B2-2, B1-4, B2-4)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4881	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



SECTION A-A C7-3
2 PL



SECTION B-B C7-3
2 PL

D4881-041 AFT LEG ASSEMBLY, LH
AUXILIARY VIEW

RELEASED
2014-07-07

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4881	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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Summerstown, ON
K0C 2E0 Canada

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Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE November 26, 2016

P.O NUMBER PO34420

ITEM DESCRIPTION**QUANTITY****COMMENTS**

D4881-042 LEG ASSEMBLY

2

ALL ITEMS HAVE BEEN LASER MARKED

D4928-042 LEG ASSEMBLY

2

D4881-041 LEG ASSEMBLY

4

16/29/18
SL



19226 Airport Road
Summerstown, ON
K0C 2E0

plprinting@bellnet.ca www.plprinting.ca

Tel.: 613 931-1241
Fax: 613 931-2560

Invoice

Number: 8802

Date: November 25, 2016

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
34420		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4881-042	2.00	4.00	✓	8.00
Laser Metal Marking, D4928-042	2.00	4.00	✓	8.00
Laser Metal Marking, D4881-041	4.00	4.00	✓	16.00

NOV 29 2016
9-886
DAG
SEP

Sub-Total	\$32.00
13.00% on 32.00	4.16
Total	\$36.16

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We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34420**

Purchase Order Date 11/23/2016

PO Print Date 11/23/2016

Page Number 1 of 2

Order From :
P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO KOC 2E0
CANADA

VC-PL001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

NOV 24 2016

Contact Name
Vendor Phone 613-931-1241

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
1	153145 ENGRAVE PART # D4881-042	D4881-042 LEG ASSEMBLY	11/29/2016 Yes 11/29/2016		2.00	\$4.00	\$8.
						Line Total:	\$8.
2	153079 ENGRAVE PART # D4928-042	D4928-042 LEG ASSEMBLY	11/29/2016 Yes 11/29/2016		2.00	\$4.00	\$8.
						Line Total:	\$8.
3	152532 ENGRAVE PART # D4881-041	D4881-041 LEG ASSEMBLY	11/29/2016 Yes 11/29/2016		4.00	\$4.00	\$16.

Note:

11/23/2016

NOV 29 2016
DAS
6
8-89